

SHIP 20 AUG

Work Order ID 122375

July-15-14 7:25:18 AM

122375

350-591-311
B122375

Page 1

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step™ LH

Start Date: 7/15/14

Start Qty: 10.00

10

Required Date: 7/15/14

Req'd Qty: 10.00

10

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MJS

Date: 14-07-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

Document Control

0.00

DAS

86

9-89

10x

100

DOCUMENT CONTROL

DC

Memo

0.00

AUG 15 2014

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

110

0.00

110

Large Fab

Large Fab

Large Fab

Memo

0.00

10x 14-07-16 PD

1-Bevel end for welding FWD ONLY ✓

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg ✓
D3272

A/RAluminum Rod M128316/M128356

3-Grind End Plate flush

DMC 14-07-24

Work Order ID 122375

July-15-14 7:25:18 AM

122375

Page 2

Item ID: D350-591-311

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop *NS2*

Start Date: 7/15/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/15/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00				10x		DAS 43 9-89	JUL 29 2014
Quality Control									

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

10x _____ DAS
43
9-89 JUL 29 2014

140 Chemical Conversion Coat per QSI005 4.1 0.00

140

HandFinish

Memo

0.00

Hand Finishing

10x _____ DHC
7/6 14-07-29

Work Order ID 122375

July-15-14 7:25:18 AM

122375

Page 3

Item ID: D350-591-311

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop

NS2

Start Date: 7/15/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/15/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00				(10)			

Quality Control

180

180

Large Fab

Large Fab

Large Fab

0.00

0.00

Memo

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod 125091

6-Grind End Plate flush

7-Install last rivet as per Dwg.

DMC 14-07-31

14-08-05

10x

DMC

14-08-05

Work Order ID 122375

July-15-14 7:25:18 AM

122375

Page 4

Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop ***NS2***

Start Date: 7/15/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/15/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC10- Inspect visual per QSI004- ground welds	0.00						DAS 43 9-89	AUG 12 2014
190						10x			
QC	Memo	0.00							

Quality Control

200 QC5- Inspect part completeness to step on W/O 0.00

200

QC

Memo

0.00

10x DAS
43
9-89 AUG 12 2014

Quality Control

210 Chemical Conversion Coat per QSI005 4.1 0.00

210

HandFinish

Memo

0.00

10 7/14-8-12

Hand Finishing

Work Order ID 122375

122375

Page 5

July-13-14 7:25:18 AM

Item ID: D350-591-311

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH

Start Date: 7/15/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/15/14 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00

OVEN TEMPERATURE: 320°

FINISH TIME: 10:30

11:30

230

Wing Walk as per dwg QSI005 4.4 Batch 11124 8000

230

HandFinish

Memo

0.00

Hand Finishing

240

QC3- Inspect Part Finish

0.00

240

QC

Memo

0.00

Quality Control

10 10/14

1064 / 14/08/14

1064 17/08/15

Work Order ID 122375

July-15-14 7:25:18 AM

122375

Page 6

Item ID: D350-591-311

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop

NS2

Start Date: 7/15/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/15/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				10			DAS 33 9-89 14-07-23
Packaging									

260 QC4- 100% Inspect kits for completeness 0.00

260

QC

Memo

0.00

Quality Control

DAS
06
9-89

10 AUG 15 2014

270 Packaging 0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311
Location: AA11

DAS
06
9-89



AUG 15 2014

Work Order ID 122375

July-15-14 7:25:18 AM

122375

Page 7

Item ID: D350-591-311
Revision ID:
Item Name: Heli-Access-Step™ LH

Accept

N900040100Setup Start ***NS1***Stop ***NS2***Start Date: 7/15/14 Start Qty: 10.00 ***10***Required Date: 7/15/14 Req'd Qty: 10.00 ***10***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MCS 14-08-18

MCS 14-08-18

Picklist Print

July-15-14 7:25:23 AM

Page 1

Work Order ID: 122375

122375

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 7/15/14

Required Date: 7/15/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No	B 121439		110	Each	0.0000	1	10			
D3272-1									**				
Step													
D3067-1		Manufactured	No			110	Each	482.0000	1	10			
D3067-1									**				
End Plate													

DHC 14-7-15

DAS
9
9-88

Location Loc Qty Loc Code

WA003	482	
101785	67	
102686	14	
116323	26	10
117776	225	
119290	150	

D3219-1

Manufactured No

110 Each 229.0000 2 20

D3219-1

Plate

**

DAS
9
9-88

Location Loc Qty Loc Code

WA003	229	
112125	8	
114934	80	20
115339	141	

Picklist Print

July-15-14 7:25:24 AM

Page 2

Work Order ID: 122375

122375

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 7/15/14

Required Date: 7/15/14

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No 180 Each 242.0000 2 20

D3066-1

Spacer

**

DMC 14-07-31

Location	Loc Qty	Loc Code
WA003	242	
106302	7	
115867	52	
115868	52	
115869	80	20 x
117799	51	

MS20600-AD4W4 Purchased No 180 Each 3,558.000 16 160

MS20600-AD4W4

Rivets

**

DMC 14-07-31

Location	Loc Qty	Loc Code
ST310	3558	
125577	215	
M128429	343	160 x
M128899	3000	

D3065-041 Manufactured No 180 Each 30.0000 1 10

D3065-041

Step Leg Assembly

**

DMC 14-07-31

Location	Loc Qty	Loc Code
WA003	30	
102830	6	
109447	2	
113075	2	
115696	20	10 x

Picklist Print

July-15-14 7:25:24 AM

Page 3

Work Order ID: 122375

122375

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 7/15/14

Required Date: 7/15/14

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180

Each

482.0000

1

10

D3067-1

End Plate

14.08.05

Location

Loc Qty

Loc Code

WA003

482

101785

67

102686

14

116323

26

117776

225

119290

150

10

AN3-35A

Purchased No

250

Each

111.0000

2

20

AN3-35A

DAS

33

9-89

14-07-23

Bolt

DAS
33
9-89

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

50

m129706

50

ST352

3

m127460

1

m128300

2

ST512

48

m128634

48

128634

DAS

31

9-89

Picklist Print

July-15-14 7:25:24 AM

Page 4

Work Order ID: 122375

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

122375

D350-591-311

Start Date: 7/15/14

Required Date: 7/15/14

Start Qty: 10.00

Required Qty: 10.00

D3235-1 Manufactured No 250 Each 390.0000 2 20

DAS

33

9-89

DAS

31

9-89

D3235-1

Mounting Lug

DAS

06

9-89

Location

Loc Qty

Loc Code

ST519

390

102818

6

105939

17

108670

43

114441

54

116383

100

116384

100

116385

70

116384

D3278-041

Manufactured No

250

Each

50.0000

1

10

DAS

33

9-89

DAS

31

9-89

D3278-041

Support Assembly

**

57-121431

DAS

06

9-89

Location

Loc Qty

Loc Code

ST521

50

102349

1

109406

1

114169

39

114940

9

57-114940

NAS1149D0463J

Purchased

No

250

Each

7,429.000

16

160

DAS

33

9-89

DAS

31

9-89

NAS1149D0463.1

WASHER

**

14-07-23

DAS

06

9-89

Location

Loc Qty

Loc Code

ST277

7429

16941

8

M126221

20

M127813

22

M127904

778

M128591

101

M128995

1500

M129390

5000

127904

July-15-14 7:25:24 AM

Shop Packet Print

Page 4

Picklist Print

July-15-14 7:25:24 AM

Page 5

Work Order ID: 122375

122375

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 7/15/14

Required Date: 7/15/14

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0563J

Purchased

No

250

Each

2,729.000

4

40

DAS

33

9-89

DAS

31

9-89

NAS1149D0563J

Washer

DAS

06

9-89

Location

Loc Qty

Loc Code

GA

201

m125807

201

ST510a

2528

m126319

536

m128257

1992

126319

AN5-36A

Purchased

No

250

Each

130.0000

2

20

DAS

33

9-89

DAS

31

9-89

AN5-36A

Belt

DAS

06

9-89

Location

Loc Qty

Loc Code

ST336

130

M126105

1

M127410

9

M127460

100

M128850

20

11T 127460
9T 128850

D2618

Manufactured

No

250

Each

173.0000

2

20

DAS

33

9-89

DAS

31

9-89

D2618

Bushing

14-07-23

DAS

06

9-89

Location

Loc Qty

Loc Code

ST008A

173

103863

5

114872

42

97780

126

11T 114872
9T 97780

Picklist Print

July-15-14 7:25:24 AM

Page 6

Work Order ID: 122375

122375

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 7/15/14

Required Date: 7/15/14

Start Qty: 10.00

Required Qty: 10.00

D2230-3

Manufactured No

250

Each

570.0000

40

DAS

33

9-89

DAS

31

9-89

D2230-3

Mounting Lug

DAS

06

9-89

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST519

563

108668

1

109344

2

114151

1

114921

86

115583

154

116378

159

116379

160

32714921

82115583

D2856-400

Manufactured No

250

f

316.2000

1.2

12

DAS

33

9-89

D2856-400

Abrasion Strip 4" Wide (Per Foot)

DAS

06

9-89

Location

Loc Qty

Loc Code

ST403

314.2

112524

98.2

117887

216

ST408

2

109578

2

112524

DAS

31

9-89

1407-23

*** cut (2) at 7.20" (D2856-400-720) ***

Picklist Print

July-15-14 7:25:24 AM

Page 7

Work Order ID: 122375

122375

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 7/15/14

Required Date: 7/15/14

Start Qty: 10.00

Required Qty: 10.00

MS21042L3 Purchased No 250 Each 5,086.000 2 20 DAS 33 9-89

MS21042L3

Nut

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST307	5086	
123900	955	
M126333	44	
M127410	13	
M127831	41	
M128401	42	
M128754	3991	

128754

AN4-13A

Purchased No

250

Each

1,079.000

8 80

AN4-13A

Bolt

DAS
31
9-89
13/14 7-23

DAS
06
9-89

Location

Loc Qty

Loc Code

FG	20	
122808	20	
GA	14	
m125709	14	
ST515	1045	
m127432	36	
m127817	24	
m128403	4	
m128739	981	

128739

DAS
31
9-89

Picklist Print

July-15-14 7:25:24 AM

Page 8

Work Order ID: 122375

122375

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 7/15/14

Required Date: 7/15/14

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

1,112.000

2

20

DAS

33

9-89

DAS

31

9-89

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST307

1112

DAS

06

9-89

117611

1

125684

8

m127304

3

m127813

500

m128810

100

m129472

500

128810

MS21042L4

Purchased

No

250

Each

4,715.000

8

80

DAS

33

9-89

MS21042L4

Locknut

14-07-23

DAS

06

9-89

Location

Loc Qty

Loc Code

ST307

4715

126275

5

m126015

12

m126275

27

m127255

71

m127376

11

m127813

971

m128300

80

m128798

2538

m129472

1000

128798

DAS

31

9-89

Picklist Print

July-15-14 7:25:24 AM

Page 9

Work Order ID: 122375

122375

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 7/15/14

Required Date: 7/15/14

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0363J

Purchased

No

250

Each

2,892.000

4

40

DAS

33

9-89

NAS1149D0363J

Washer

14-09-30

68-6

90

SVD

Location

Loc Qty

Loc Code

GA

23

124392

23

ST276

8

m123441

8

ST510a

2861

m126319

6

m128429

2855

DAS

31

9-89

128429

DART

DESIGN <i>90</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

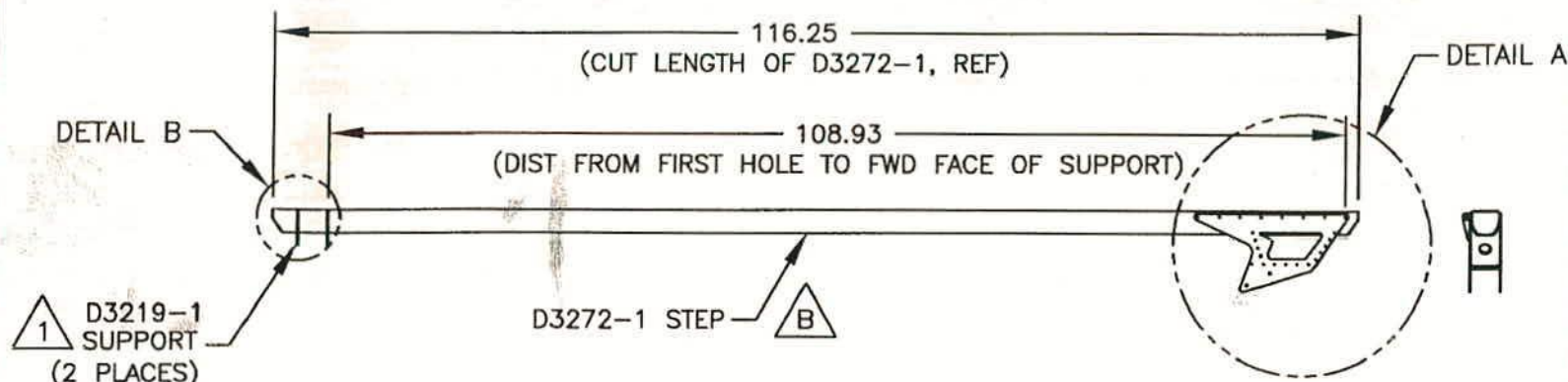
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122375 M45
14-07-15

Copyright © 2004 by DART AEROSPACE LTD

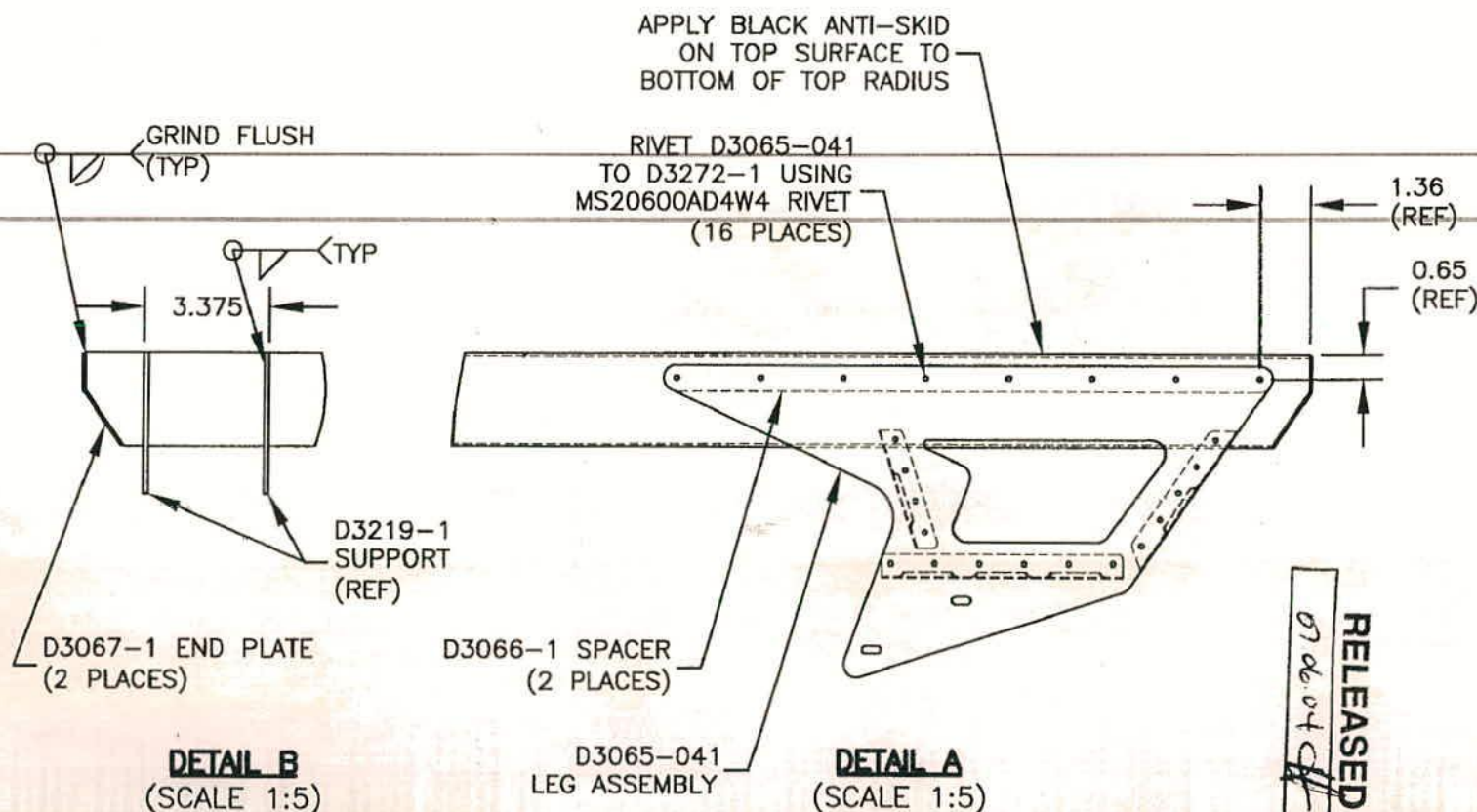
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	AP	DRAWN BY	AS	DART AEROSPACE LTD	REV. B
CHECKED	CE	APPROVED	AS	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 3
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	SCALE	1:20

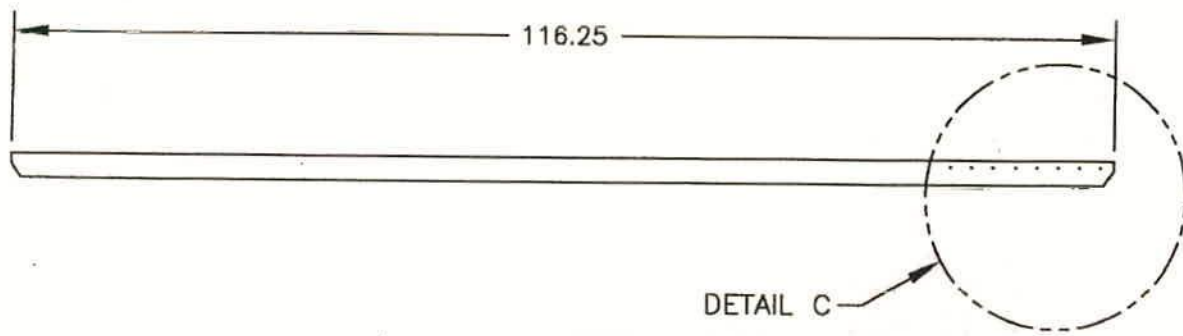


D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

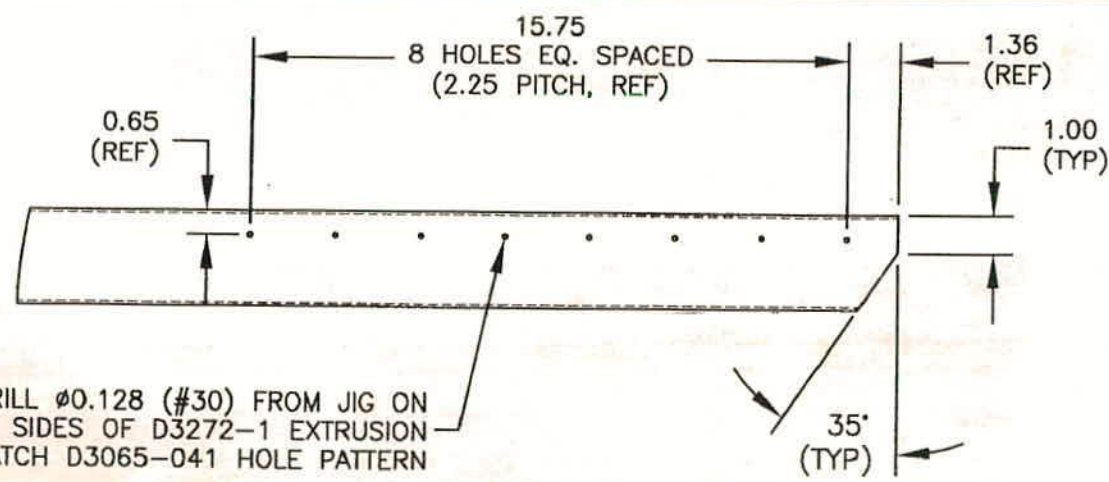




DESIGN	APPROVED	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE		TITLE	REV. B
07.05.18		STEP ASSEMBLY, HI LONG	SHEET 3 OF 3
			SCALE
			1:20



△ B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED
07.06.04